

Work Order ID 56077

February 9, 2010 3:36:29 PM



Page 1

Item ID: D3656-1

Accept



Setup Start



Revision ID:

Stop



Item Name: PANEL

Start Date: 2/09/10

Start Qty: 3.00

5



Cust Item ID:

Required Date: 2/19/10

Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

u

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3656

Rev B

100



HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks to fit frame size

BB
10/04/07
X 5

110



THERMOFORMING MACHINE

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3656-1 and Folio FTA 015 using tool DT
8986 □ Dwg. Rev. 3 □ Folio Rev. C

BB
10/04/27
X 4
X 15
P.T.O.

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

Visually inspect for proper formation of each part

BB
10/04/27
X 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3656-1 PAR #: _____ Fault Category: Thermal forming NCR: Yes No DQA: Yes Date: 10.04.28
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 10/05/04

NCR: <u>56072</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/04/28</u>	<u>110</u>	<u>OVEN OVER DID NOT RETURN OVER HEATED PARTS Did not set off the return switch R.C. program glitch</u>	<u>[Signature]</u>	<u>Scrap parts at 1 panel. No replace - no extra material.</u>	<u>[Signature]</u> <u>10/04/28</u>	<u>S</u> <u>10/04/29</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>10/04.28</u>

NOTE: Date & initial all entries

Work Order ID 56077

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Page 2

Item ID: D3656-1

Accept



Setup Start



Revision ID:

Stop



Item Name: PANEL

Start Date: 2/09/10

Start Qty: 3.00



Cust Item ID:

Required Date: 2/19/10

Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

OK 10/04/27
X4

140

HAND FINISHING THERMOFORMING

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions as per dwg D3656

OK 10/04/29
X4

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Check dimensions to ensure conformity to drawing tolerances.

OK 10/04/29
X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56077

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Page 3

Item ID: D3656-1

Accept



Setup Start



Revision ID:

Stop



Item Name: PANEL

Start Date: 2/09/10

Start Qty: 3.00



Cust Item ID:

Required Date: 2/19/10

Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

S. Solerba



QC

Memo

0.00

Quality Control



PTO

170

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

10-5-3 *BY* *\$*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/04 *AS*

BS 10-5-04

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3656-1 PAR #: _____ Fault Category: Thermoforming NCR: (Yes) No DQA: _____ Date: 18.05.06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/05/07

NCR: <u>56077</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/04/29</u>	<u>#160</u>	Found orange ^{markings} streaks in the part. R.C. Pulled across the table. 2	<u>[Signature]</u> <u>10.04.29</u> <u>OS1012</u>	Scrap & Destroy Q4 x1 will not be	<u>[Signature]</u> <u>10/04/29</u>	<u>[Signature]</u> <u>10/05/07</u>	<u>[Signature]</u> <u>10.04.29</u> <u>OS1012</u>	<u>[Signature]</u> <u>12/04/29</u>

NOTE: Date & initial all entries

Picklist Print

February 9, 2010 3:36:33 PM

Page 1

Work Order ID: 56077

Parent Item: D3656-1

Parent Item Name: PANEL

Comments: IPP Rev. A 07/12/13 New issue DL verified by:DD
IPP Rev. B 08/09/25 Dwg. Update DL.

Start Date: 2/09/10

Required Date: 2/19/10

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	211.4885	96.0000			



GE PLASTICS LEXAN SHEET

Warehouse	Loc Qty	Loc Code
<u>Location</u>		

Main Warehouse

MAT

211.4884526

107574

16.62

111973

180.609853

112176

14.2586

114459

3
2

BB
10/04/27
XS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	56077
Description: Panel		Part Number:	D3656-1
Inspection Dwg: D3656	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Free of visual flaws (bumps, cracks, voids, etc.)	✓			

Measured by: BB

Date: 10/04/29

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070	Min	.072	✓			
0.050	Min	.061	✓			
24.7	REF	24.875	✓			
0.7	REF	0.75	✓			

Measured by: BB

Date: 10/04/29

Audited by: Oh

Date: 10/04/29

Prototype Approval:

N/A

Date:

N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DL	
B	09.09.15	Dimensions updated per Dwg Rev B	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

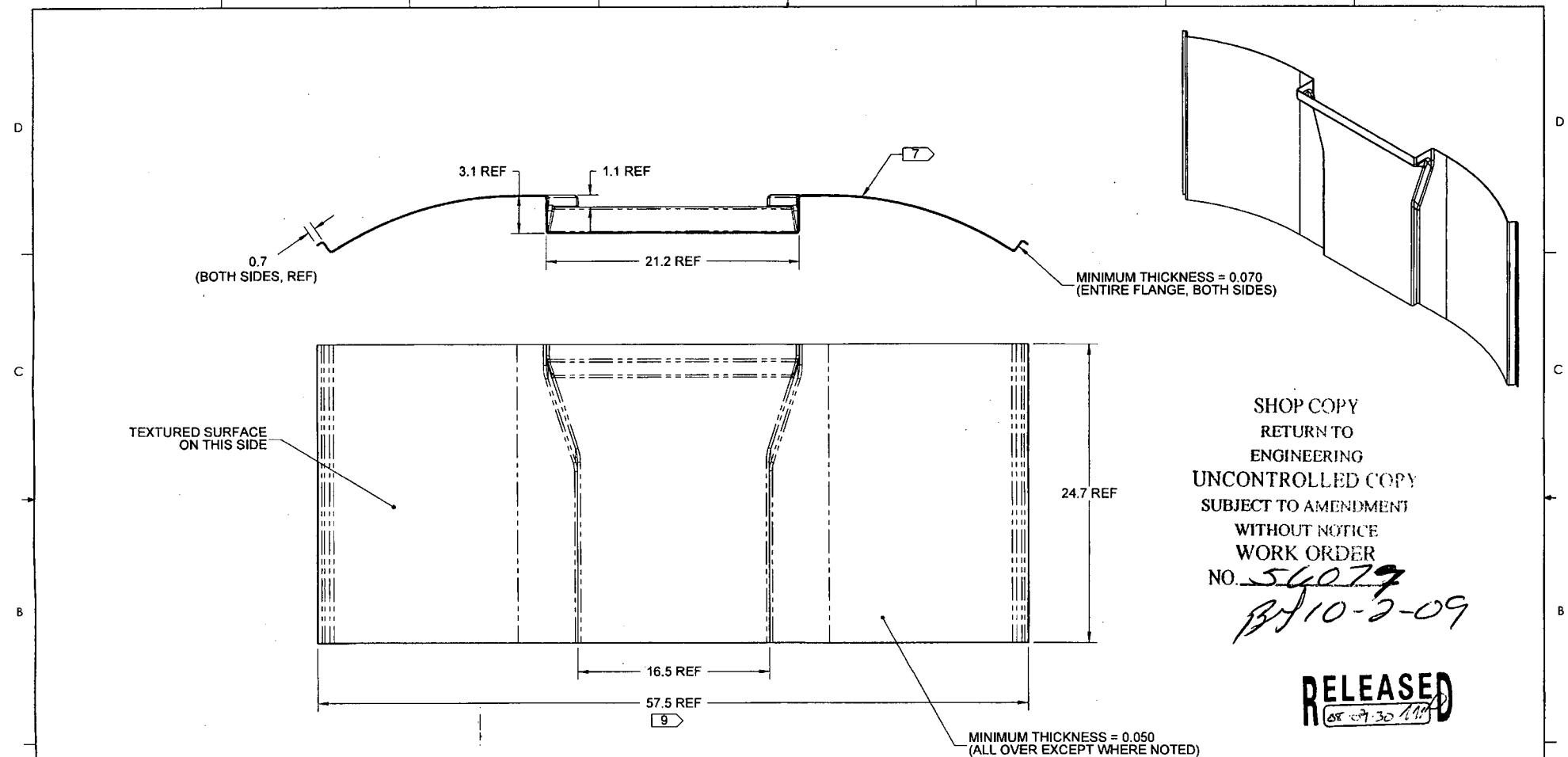
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56079
BY 10-2-09

RELEASED
08-09-30 11:11

D3656-1 PANEL

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022 TRIM PER DT8986
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 6.6 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

B	REMOVE SKYLIGHT CUTOUTS, UPDATED NOTE 2 (A6-2); REASON: EASE OF MANUFACTURE AND CUSTOMER REQUEST	PH	08.09.18
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE		
DRAWN	PH		
CHECKED	LE		
MFG. APPR.	LE		
APPROVED	LE		
DE APPR.	LE		
DATE	08.09.18		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3656 TITLE PANEL REV. B SHEET 1 OF 2 SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

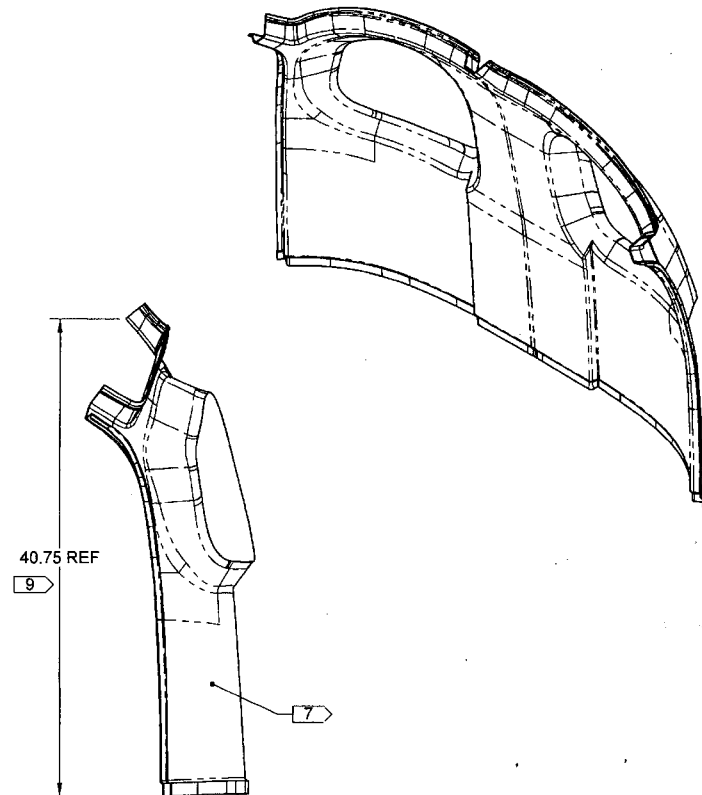
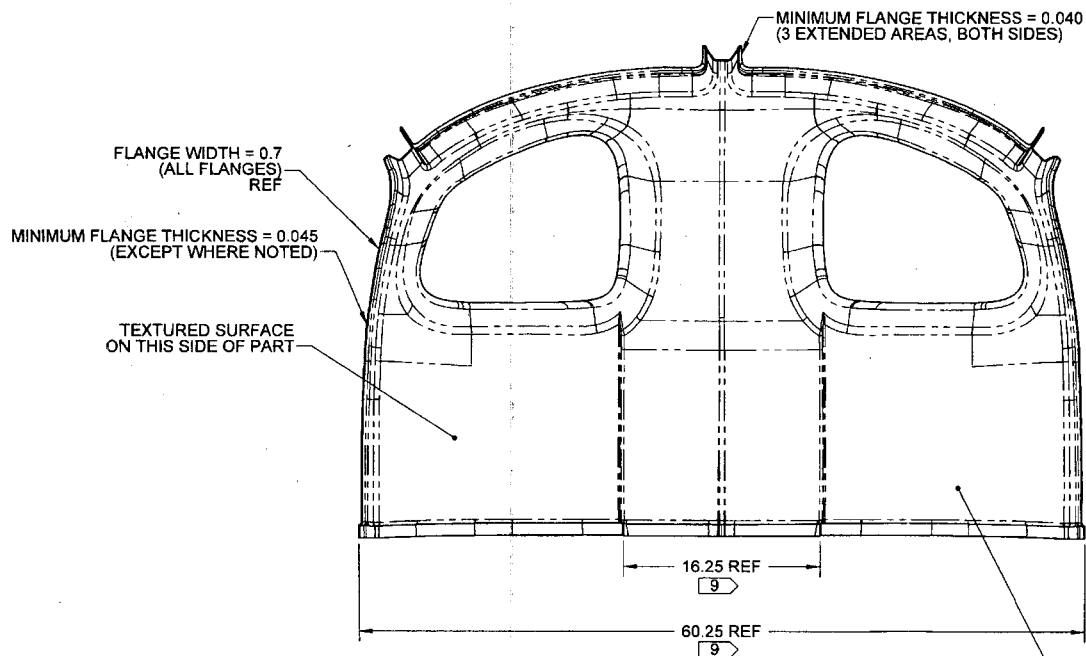
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3656-3 PANEL

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8987 PER QSI 022 TRIM PER DT8987
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 8.7 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

RELEASED
06-09-3014

RELEASED

DESIGN	CE	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3656	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	08.09.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries